



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*NS1\***

Stop \*NS2\*

\*6\*

**\*6\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

130

## Small Fab

0.00

### Small Fab

## Memo

0.00

## Small Fab

1-Deburr2-Roll as per Dwg D3276

0.00

140

NC BRAKE

0.00

Brake NC

## Memo

Brake NC

Form as per Dwg D3276

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

QC

## Memo

## Quality Control

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NOTE: Date & initial all entries

# Work Order ID 79183

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**\*79183\***

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Item ID: D3276-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Baffle Assembly RH  
 Start Date: 23/01/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

*6XØ M-L 12/03/06*

170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*170*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>11h10</u> OVEN TEMPERATURE: <u>M120222</u> FINISH TIME: <u>11h40</u> <u>320°F</u>								

*6 M/L 12/03/15*

180	QC3- Inspect Part Finish	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

*6 BR 12-3-15.*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 79183

**\*79183\***

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January-23-12 10:47:11 AM

Item ID: D3276-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Baffle Assembly RH  
 Start Date: 23/01/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 06/02/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
<b>*190*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3276								
200		0.00							
<b>*200*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
210		0.00							
<b>*210*</b>	Identify as per dwg & Stock Location: <b>S81</b>								
Packaging	Memo	0.00							
Packaging									

*Handwritten signature and date: 12/03/20*

*Handwritten number: 6*

*Handwritten signature and date: 12-03-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



**\*79183\***

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**\*N900040100\***

**Setup Start \*NS1\***

Stop **\*NS2\***

**\*6\***

**\*6\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

**\*220\***

0.00

12/3/21 *[Signature]*  
mf  
12-03-21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 79183

\*79183\*

Parent Item: D3276-042

\*D3276-042\*

Parent Item Name: Baffle Assembly RH

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-12-06 JLM  
IPP Rev:B Now on Waterjet 06-09-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-3 *D3276-3* Decal		Manufactured	No			110	Each	15.0000	1	6		12/03/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST035				15					
				77063				15					
D2464 *D2464* 3/4 Seal		Manufactured	No			190	f	238.3800	2.25	13.5		12/03/19	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST404				238.38					
				61878				238.38					
M6061T6S.040 *M6061T6S 040* 6061-T6 .040 Sheet		Purchased	No			190	sf	330.9100	1.0205	6.445263		6.8	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				330.91					
				113004				2.5					
				117653				40.91					
				120154				95.5					
				120218				192					

W/O:		WORK ORDER CHANGES					
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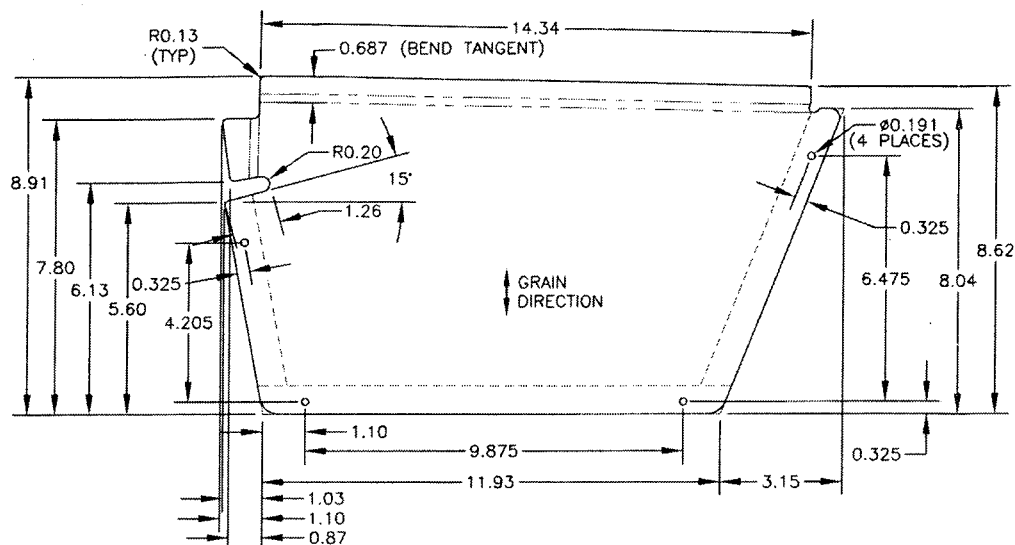
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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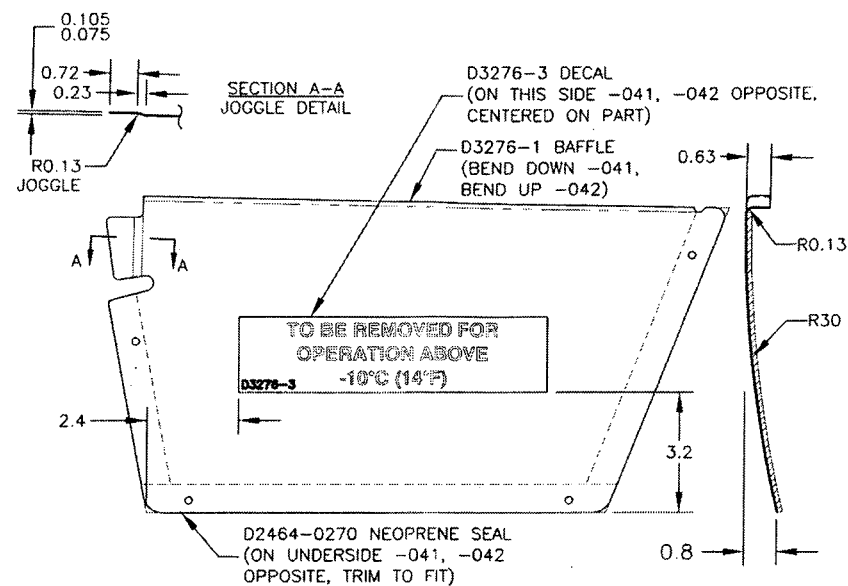
**NOTE:** Date & initial all entries





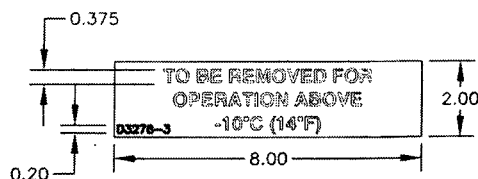
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

#### D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCLASSIFIED  
SECRET

79183 M.L.S.  
12/01/23

RELEASED  
05.01.25

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DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	/	APPROVED	/
DATE	05.01.25	DRAWING NO.	D3276
		TITLE	BAFFLE ASSEMBLY
		REV. B	SHEET 1 OF 1
		SCALE	1:3

**DART** DART AEROSPACE LTD.  
HAMMERSLEY, ONTARIO, CANADA

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